

Work Order ID 131887

131887

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Tuesday, April 21, 2015 2:08:40 PM

Item ID: D3214-1 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Decal

Start Date: 4/20/15 Start Qty: 10.00 *10* Cust Item ID:

Required Date: 4/20/15 Req'd Qty: 10.00 *10* Customer:

Reference:

Approvals: Process Plan: MLS Date: 15-04-22 Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3214	Rev C								
100	SHEAR	0.00							
100									
Waterjet	Memo	0.01							
FLOW CNC Waterjet	CUT AS PER DWG								
	DWG REV: <u>C</u>								
	PROG REV: <u>C</u>								
	DEBURR								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00							
Quality Control									

(10)

12/15/04/29

(10)

12/15/04/29

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐			
		OTHER : ☐			

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Page 2

Tuesday, April 21, 2015 2:08:40 PM

Item ID: D3214-1 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Decal
Start Date: 4/20/15 Start Qty: 10.00 ***10*** Cust Item ID:
Required Date: 4/20/15 Req'd Qty: 10.00 ***10*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp DAS 38 9-89
112 *112* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				(10)			APR 29 2015
120 *120* HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				(10)			12/15/05/02
130 *130* Powdercoat Powder Coating	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3 M 123480 Memo START TIME: <u>11:10</u> OVEN TEMPERATURE: <u>320</u> FINISH TIME: <u>11:40</u>	0.00 0.00				10	15-5-5		28 34 9-89

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Work Order update only ☐

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OTHER :					

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15/05/08

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Picklist Print

Tuesday, April 21, 2015 2:08:39 PM

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Work Order ID: 131887

131887

Parent Item: D3214-1

D3214-1

Parent Item Name: Decal

Start Date: 4/20/15

Required Date: 4/20/15

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP A04.04.15New issueKJ/RF

IPP Rev:B Now 6061-T6 06-06-23 JLM

IPP REV

C:NOW ON WATERJET 13-02-08 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.080		Purchased		No		110	sf	204.6918	0.0743	0.782105			

M6061T6S 080

6061-T6 .080 Sheet

04/15/2015

Location

Loc Qty

Loc Code

MAT009

96

m132037

96

MAT020

108.6918

m130530

41.6

m130560

67.0918

1.8

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OTHER :					



15-04-22

RELEASED
2013-02-07

NOTES:

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027), 0.080 THICK
REF DART SPEC M061T6S.08 OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016), 0.080 THICK
REF DART SPEC M5052H32S.080
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "BLACK SANDTEX" (4.3.5.7) PER DART QSI 005 4.3
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: LESS THAN 0.010 lbs
- 8) ENGRAVE ALL LETTERS TO A DEPTH OF 0.005 USING A TOOL RADIUS OF 0.039 AFTER POWDER COAT.

C	FORMAT TO CURRENT STDs: 3 HOLES ADDED; Ø0.008 4PL WAS 1PL REF PAR12-186	SFM	13.01.15
B	ADD 6061-T6 MATERIAL	CB	08.05.20
A	NEW ISSUE	CB	04.01.27
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3214 REV. C SHEET 1 OF 1 TITLE PLACARD SCALE NTS	
DRAWN	SFM		
CHECKED	AS		
MFG. APPR.	<i>[Signature]</i>		
APPROVED	<i>[Signature]</i>		
DE APPR.	<i>[Signature]</i>		
DATE	13.01.15	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	